



DESCRIPTION

Solid wire for welding various Al-Si alloys

Widely used thanks to its excellent aesthetic characteristics and smoothness. The high Si content increases fluidity and reduces sensitivity to weld cracking and generates higher shear strength in fillet welding. Applications include general purpose constructions, components for the automotive industry, heat exchangers, body panels, brazing of aluminum sheets, profiles and casting. It's characterized by bright and almost smut free welding but not suitable for post weld anodizing.

SPECIFICATIONS

ISO 18273	S Al4047 A	AWS A5.10	ER4047
Werkstoff Number	3.2585	Certifications	CE
Shielding	I1	Positions	PA, PB, PC, PD, PE, PF, PG
Current	DC+	Packaging Type	Drums, B300, D200 and D100 spools.

ASME QUALIFICATIONS

F-No (QW432)	23
A-No (QW442)	-

FERRITE

-
---

PREN

-
---

HARDNESS

-
---

CHEM. COMP. %

DEFAULT

Mn	0.05
Si	11.7
Cu	0.006
Fe	0.13
Ti	0.02
Zn	0.01
Mg	0.006

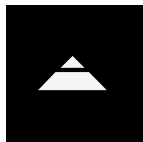
MECHANICAL PROPERTIES

	MIN	VARIANT
Tensile strength R <sub>m</sub> MPa	-	125
Yield strength R <sub>p0.2</sub> MPa	0	70
Elongation A (L <sub>0</sub> =5d <sub>0</sub> ) %	0	5
Impact Charpy ISO-V	-	-
Impact Charpy ISO-V	-	-

WELDING PARAMETERS

	1.2 mm	1.6 mm
Ampere	110A - 130A	200A - 300A
Voltage	19V - 23V	22V - 26V
Packaging	Ø 0,8÷1,6mm	Ø 0,8÷1,6mm
Packaging Type	Drums, B300, D200 and D100 spools.	Drums, B300, D200 and D100 spools.





# AlSi

## DESCRIPTION

ALUMINIUM ALLOYS  
AlSi

### APPLICATION

Widely utilized alloys, known for excellent aesthetic characteristics and smoothness, these alloys exhibit low sensitivity to weld cracking when paired with 6000 series base alloys. Their lower melting point and increased fluidity (due to Silicon content) result in better weld appearance compared to 5000 series filler alloys. However, the weld metal is not suitable for decorative anodizing. Applications span general constructions and the automotive industry, offering good mechanical properties and excellent corrosion resistance. The low melting point minimizes deformations in the parent metal, and the higher silicon content enhances fluidity while reducing the risk of hot cracking. This alloy is commonly employed for brazing aluminum sheets, extrusions, casting, and applications involving sustained elevated temperatures

### ALLOY TYPE

Consumables for welding aluminum alloys alloyed with Mg and Si.

### MICROSTRUCTURE

Face-centered cubic lattice.

### MATERIALS

The alloy is suitable for sustained elevated temperature applications (> 65 °C). The alloy is designed for welding heat treatable base alloys.

#### EN W.Nr.:

**DAIKOW AlSi5, G-TECH 605::** EN AW-Al Si5A (4043A), EN AW-Al Mg1SiCu (6061), EN AW-Al SiMg(A) (6005A), EN AW-Al Zn4,5Mg1 (7020), EN AW-Al MgSi (6060), AlMgSi0,5, AlMgSi0,7, AlMgSi0,8, EN AW-Al Si1MgMn (6082)

**DAIKOW AlSi12, G-TECH 601::** AlMgSi1, AlMgSi0,8, G-AlSi12, G-AlSi11, G-CuAlSi12(Cu), G-AlSi10Mg, G-AlSi10Mg(Cu), G-AlSi9Mg, G-AlSi9Cu3, G-AlSi7Mg, GAlSi6Cu4)

